

Date: Wednesday, 1/23/2008 11:36:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 36919A	
Estimate Number : 10143	
P.O. Number :	Part Number : D20135
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 36886A	Material :
Written By :	Due Date : 1/30/2008 Qty: 5 Um: Each
Checked & Approved By : <u>10 08 01 23</u>	
Comment : Est Rev: A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 9.0825, f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M107 093 (5) SB 08/02/12 (5)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

- 1-Punch as per template D2013-T5 and Dwg D2013
- 2-Flatten ends of D2013-5 tube as per Dwg D2013 using DT8545
- 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 identify as D2013-5.
- 4-Deburr as required

SB 08/02/12 (5)
FF 08-02-13 (5)
FF 08-02-15 (5)
FF 08-02-13 (5)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:36:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 36919A

Part Number: D20135

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/20

Job Completion



mi 2008/2/20

(5)

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

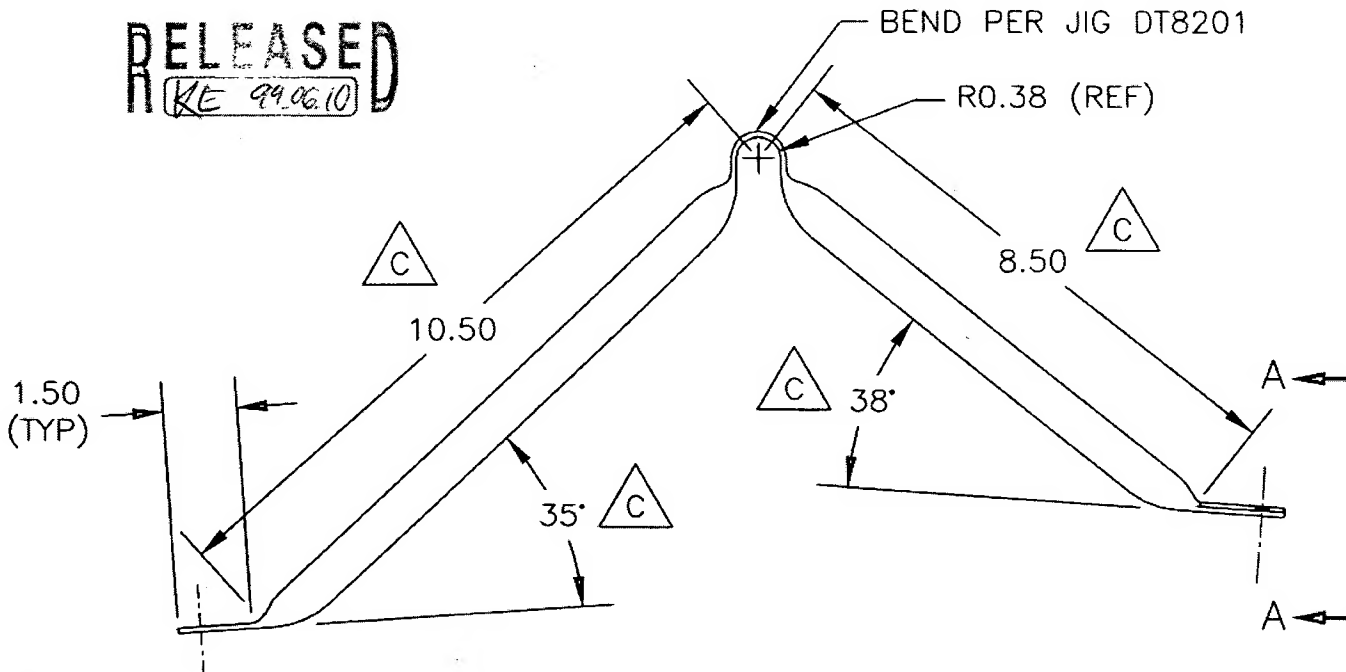
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

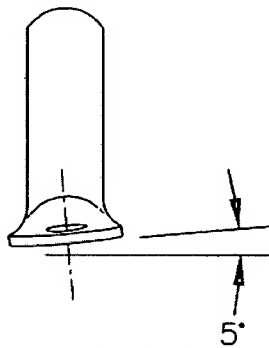
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
KE 99.06.10



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



VIEW A-A

DRILL $\varnothing 0.257$ (TYP)

0.400 (TYP)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 36419A

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

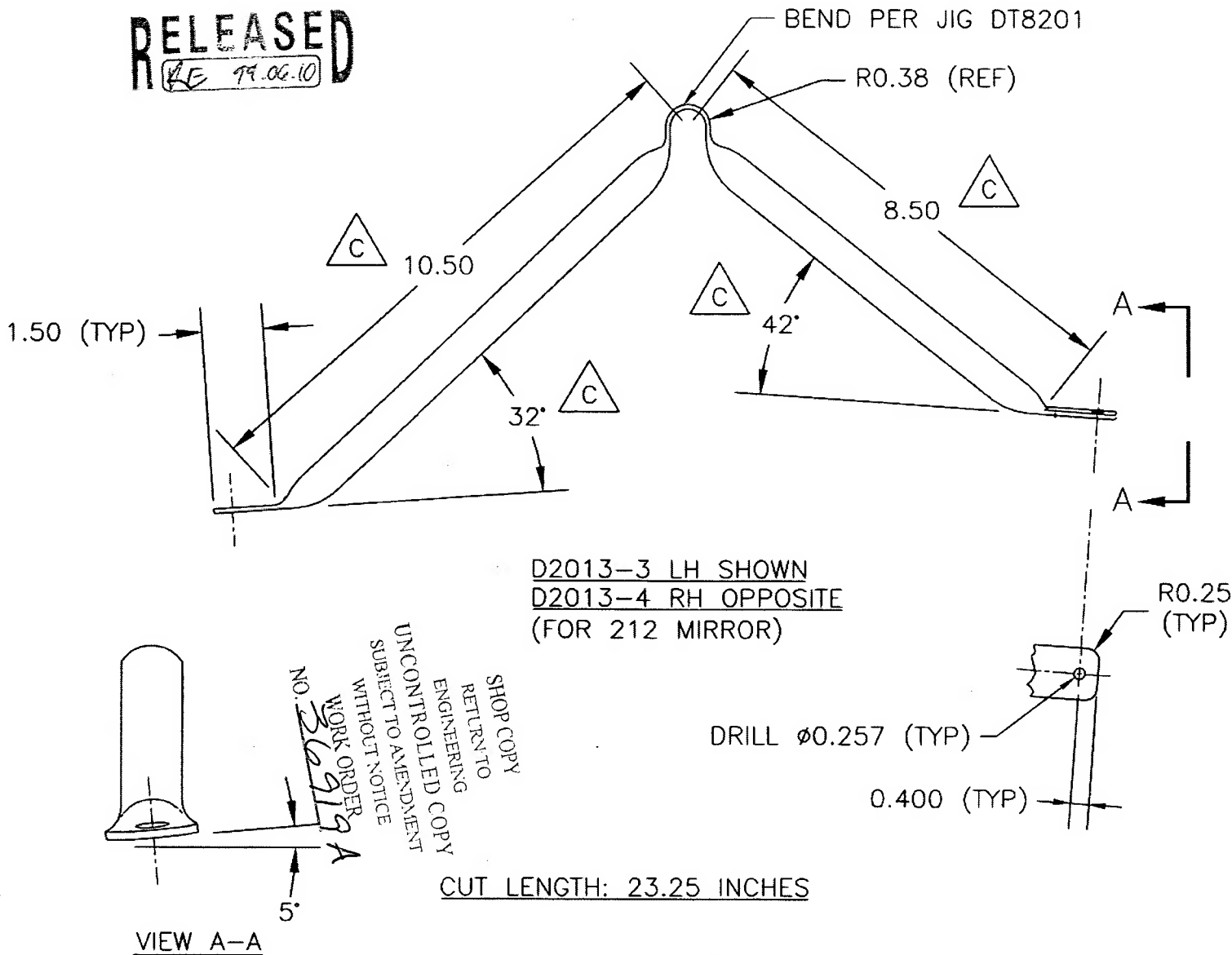
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
JB.	RF		
CHECKED KE	APPROVED RF	DRAWING NO. D2013	SHEET 1 OF 3
DATE 99.06.07		TITLE MIRROR BRACKET	SCALE NTS
A	90.10.22	NEW ISSUE	
B	94.06.15	REDRAWN	
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	

RELEASED
RE 79.06.10

DART

QA CONTROLLED

DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAMESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 2 OF 3
		SCALE	NTS	

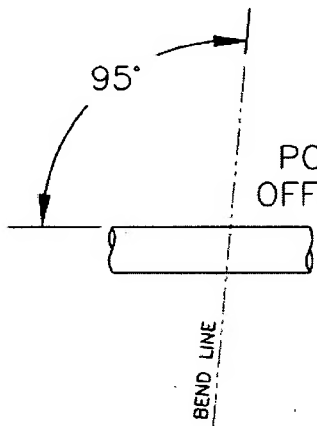
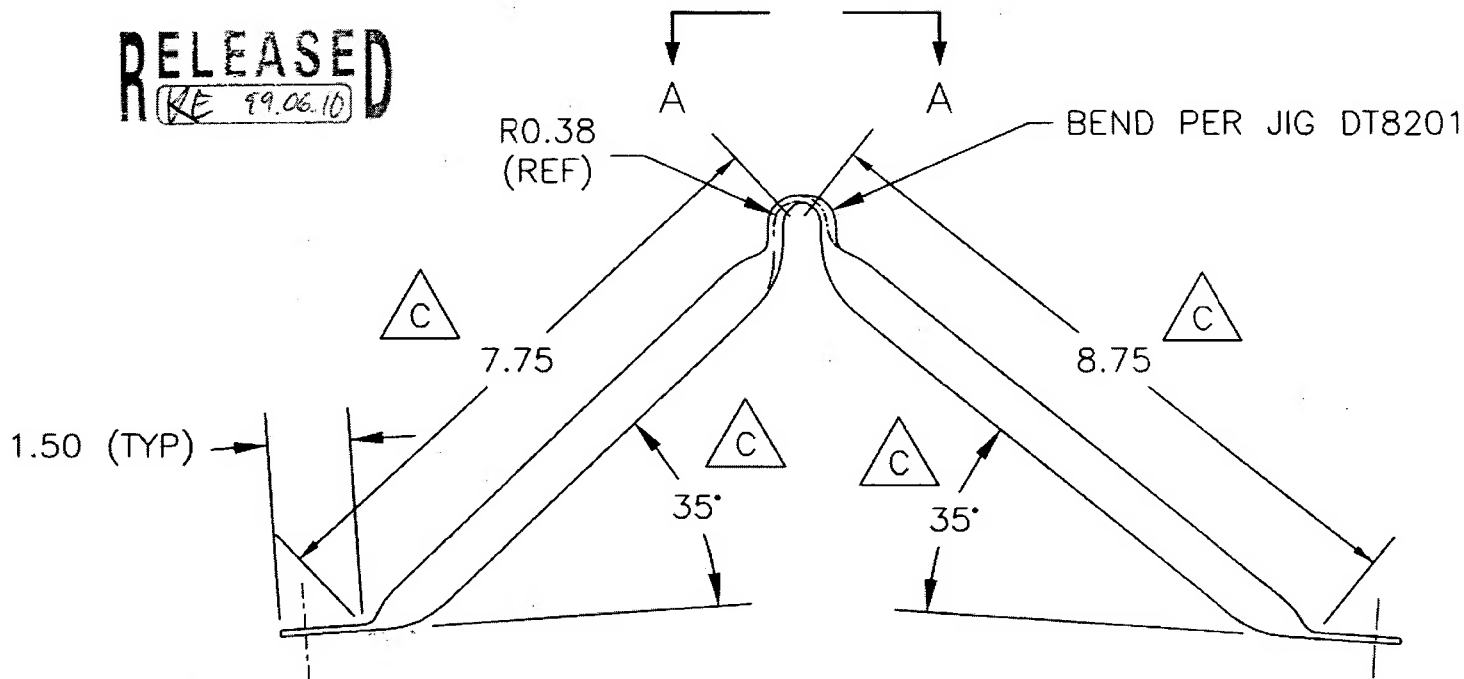


RELEASED
(KE 99.06.10)

DART

ISSUED
COPY

DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 3 OF 3
		SCALE	NTS	



POSITION TUBE
OFFSET 5°

NO. 36919A
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
CONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY
RETURN TO
JIG

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

DRILL Ø0.257 (TYP)

0.400 (TYP)

R0.25
(TYP)

LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

VIEW A-A

Date: Wednesday, 1/23/2008 11:36:29 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 36919C	
Estimate Number : 10145	
P.O. Number :	Part Number : D2037101
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D2037 REV C3
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C3
Previous Run : 36909	Material :
Written By :	Due Date : 1/30/2008 Qty: 5 Um: Each
Checked & Approved By : <u>08 01 23</u>	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 4.1118 f(s)/Unit Total : 20.5590 f(s)
Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)
Batch: M 107098 83 08/02/12 (5)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1 83 08/02/12 (5)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP 08 02 20 (5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 02410 08 02 20 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 28/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:36:29 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 36919C

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

Dec 12/20

Job Completion



mini 2008/2/20

(5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

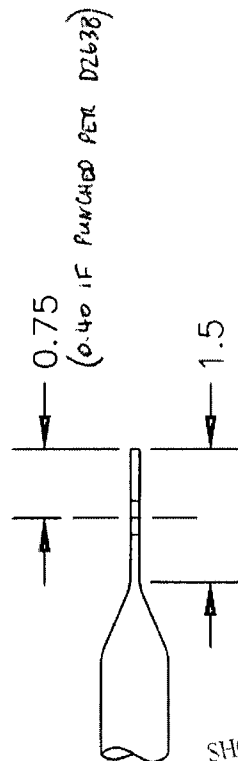
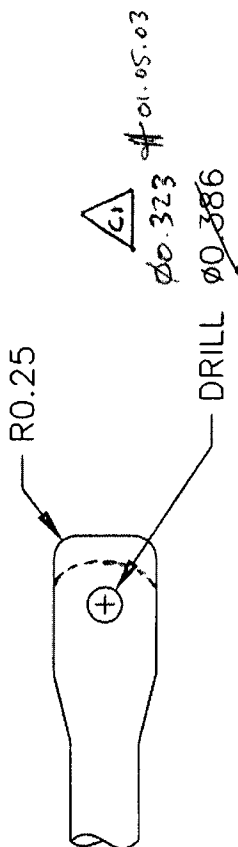
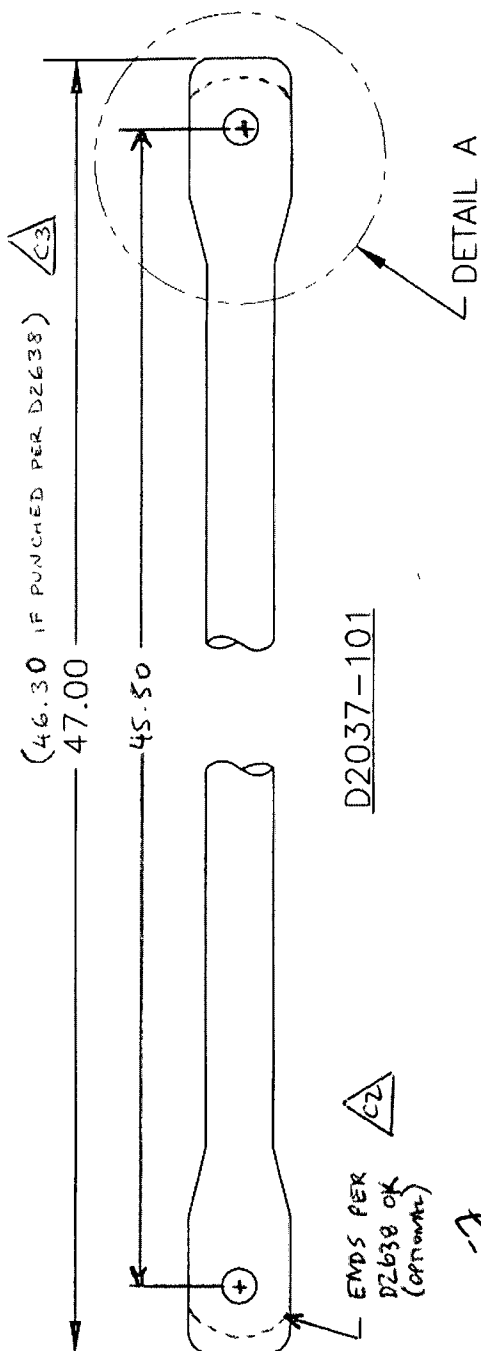
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2037	REV. C SHEET 1 OF 1
DATE 99.06.07	TITLE ARM		SCALE NTS
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1	# IP 01.05.03	CHANGE TO $\phi 0.323$	
C2	# IP 02.06.14	ADD PUNCH PER D2638 AS OPTION	



RELEASED
KE 99.06.10

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36919C

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3 # 05.04.27 ADD 46.30 PUNCHED PER D2638

Date: Wednesday, 1/23/2008 11:36:17 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 36919B	
Estimate Number : 10144	
P.O. Number :	Part Number : D20136
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 36886B	Material :
Written By :	Due Date : 1/30/2008 Qty: 5 Um: Each
Checked & Approved By : <u>AD 08 01 23</u>	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1 0	M304TR0750W049	304 RD Tube 750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 9.0825 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M 105988 (2) M 107098 3 SB 08/02/12 (5)

2 0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per template D2013-T5 and Dwg D2013

SB 08/02/12 (5)

2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545

3-Bend tube as per Dwg D2013 using Jig DT8201 Identify as D2013-6.

FF 08-02-15 (5)

4-Deburr as required

08/02/13 (5)

3 0	QC5	INSPECT WORK TO CURRENT STEP
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PTO

Comment: INSPECT WORK TO CURRENT STEP

08-2-20 (4)

4 0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

12/2/20 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2013-6 PAR #: N/A Fault Category: Prod/Process ^{material} NCR: Yes No DQA: Yes Date: 08/02/22
 QA: N/C Closed: Yes Date: 08/02/22

NCR: <u>36919B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-02-20	20	1 part scrap. Bent incorrectly. R.C: Human error	<i>[Signature]</i>	Scrap - destroyed No replace	<i>[Signature]</i> 08/02/20	<i>[Signature]</i> 08-02-20	<i>[Signature]</i>	<i>[Signature]</i> 08-02-20

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:36:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 36919B

Part Number: D20136

Job Number:



Seq. #:

Machine Or Operation:

Description :

50

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2008/2/20 (4)

h

2008/2/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

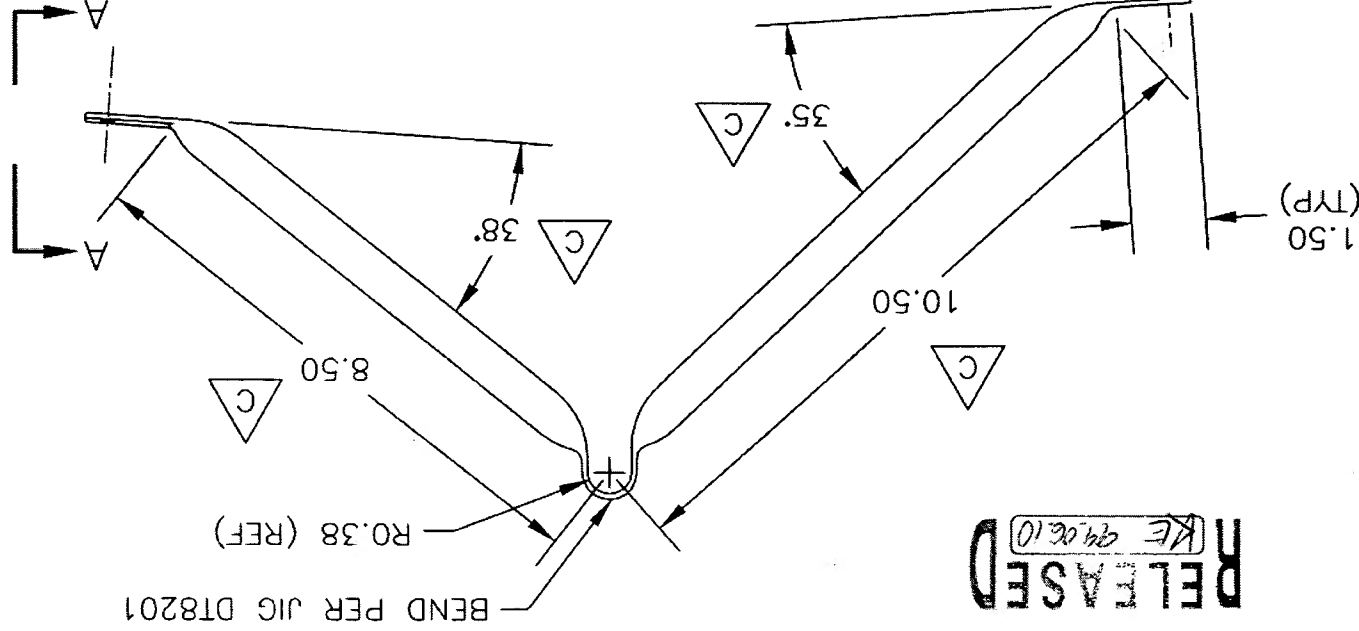
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

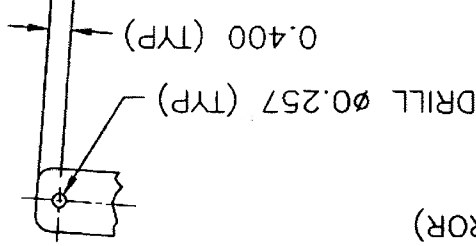
NOTE: Date & initial all entries



DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	KE	APPROVED	DRAWING NO.	D2013	REV. C
DATE	99.06.07		TITLE	MIRROR BRACKET	SHEET 1 OF 3
A	90.10.22		SCALE	NTS	
B	94.06.15			NEW ISSUE	
C	99.06.07			REDRAWN	
REDRAWN, CHANGE OF DIMENSIONS					



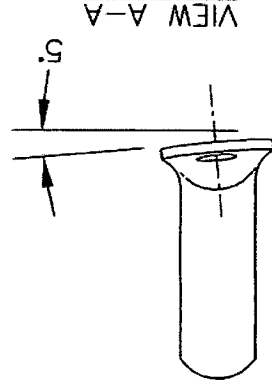
D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

CUT LENGTH: 23.25 INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36919B

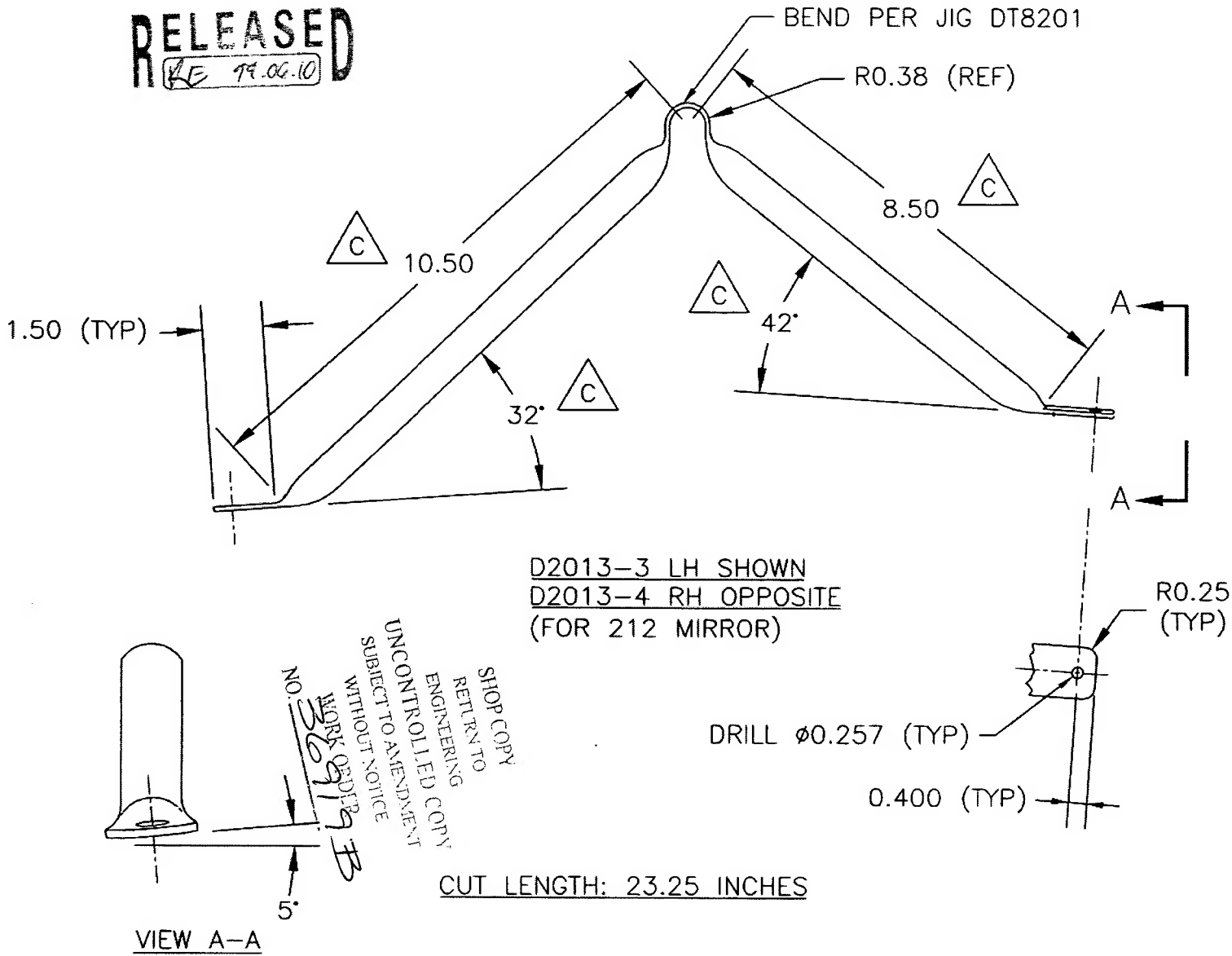


RELEASED
RE 79.06.10

DART

QC COPY ISSUED

DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 2 OF 3
		SCALE	NTS	



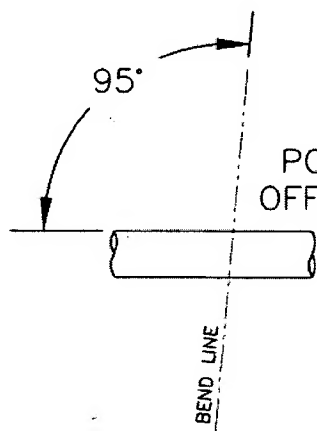
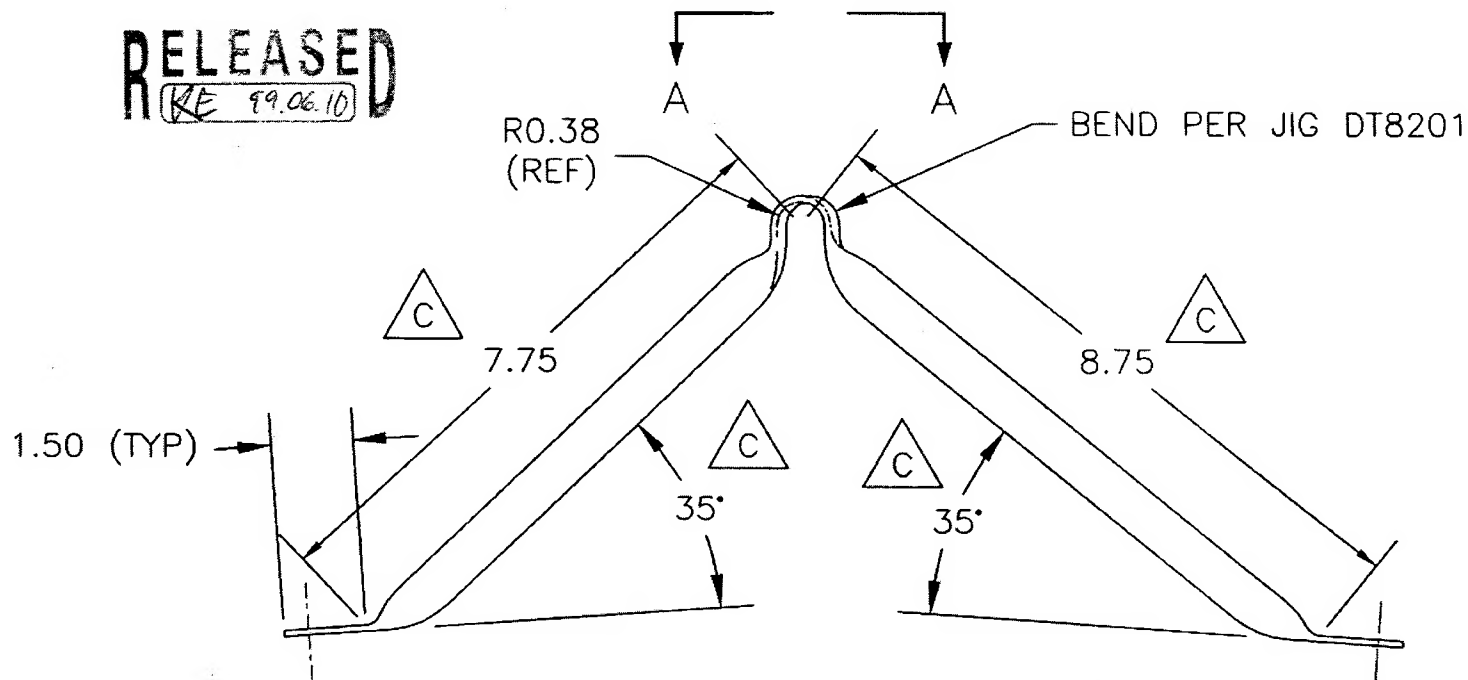
MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

RELEASED
KE 99.06.10

DART



DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 3 OF 3
		SCALE	NTS	



VIEW A-A

POSITION TUBE
OFFSET 5°

NO. 369197
WORK ORDER
SUBJECT TO ADVANCE
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY
CONTROLLED COPY

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

DRILL $\varnothing 0.257$ (TYP)

0.400 (TYP)

R0.25
(TYP)

LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL